

Date: Wednesday, 5/10/2006 9:20:01 AM  
User: Kim Johnston

## **Process Sheet**

|   |  |   |                      |
|---|--|---|----------------------|
| Customer  | CU-DAR001 Dart Helicopters Services                                | Drawing Name  | STOP                 |
| Job Number  | 27050A   |   |                      |
| Estimate Number   | 10731  |   |                      |
| P.O. Number   | N/A  | Part Number   | : D23243             |
| This Issue  | 5/10/2006  | S.O. No.  | N/A                  |
| Prsht Rev.  | NC   | Drawing Number  | : D2324 REV.C        |
| First Issue   | N/A  | Project Number  | : N/A                |
| Previous Run  | 25820A   | Drawing Revision  | : C                  |
| Written By  | See COMMENT Below  |   | Material : N/A       |
| Checked & Approved By   | <u>John O'Sullivan</u>   |   | Due Date : 5/30/2006 |
| Comment   | Est: B 03.02.28 Reformat; Incorporated D2324-3 & D2324-5 K<br>J/RF |   |                      |
| <b>Additional Product</b><br><br>Job Number:   |  |   |                      |
| Seq. #:   | Machine Or Operation:  | Description :   |                      |
| 1.0   | M6061T6B0750X00750   | 6061-T6 Bar .75" x .75"<br>                  |                      |
| Comment: Qty.: 0.5565 f(s)/Unit Total: 11.1300 f(s)<br>6061-T6 Bar 0.75" x 0.75"<br>Material: 6061-T6/6511 (QQ-A-200/8) or (QQ-A-225/8) or 5052-H34 (QQ-A-225/7) or (QQ-A-250/8)<br>(M6061T6B0.750x00.750) Batch: <u>M100742</u> SD 06.05.17                    |  |   |                      |
| 2.0   | BAND SAW   | BAND SAW<br>                               |                      |
| Comment: BAND SAW<br>Cut blanks: (0.75" x 0.75") x 5.75" Long Bar SD 06.05.17    |  |   |                      |
| 3.0   | HAAS1  | HAAS CNC VERTICAL MACHINING #1<br>         |                      |
| Comment: HAAS CNC VERTICAL MACHINING #1<br>1- Machine as per Folio D2324-3 and Dwg D2324<br>2- Deburr and Tumble to remove sharp edges<br>Identify as D2324-3 SD 06.05.17  |  |   |                      |
| 4.0   | QC2  | INSPECT PARTS AS THEY COME OFF MACHINE<br> |                      |
| Comment: INSPECT PARTS AS THEY COME OFF MACHINE SD 06.05.17    |  |   |                      |
| 5.0   | QC8  | SECOND CHECK<br>                           |                      |
| Comment: SECOND CHECK SG 06105118 30  |  |   |                      |

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                 |                          |
|------|------|--------------------|----|------|-----|---------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Mfg / Design<br>Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                 |                          |
|      |      |                    |    |      |     |                                 |                          |

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                  |                |                           |                        |                          |
|------|------|----------------------------------|-----------------------------|----------------------------------|----------------|---------------------------|------------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                  |                | Verification<br>Section C | Approval<br>Design Mgr | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Design Mgr       | Action Description<br>Design Mgr | Sign &<br>Date |                           |                        |                          |
|      |      |                                  |                             |                                  |                |                           |                        |                          |
|      |      |                                  |                             |                                  |                |                           |                        |                          |
|      |      |                                  |                             |                                  |                |                           |                        |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 06/05/25

NOTE: Date &amp; initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Date: Wednesday, 5/10/2006 9:20:01 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STOP

Job Number: 27050A

Part Number: D23243

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

DR 06/05/23 (20)

7.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT ALODINE

8.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST37

DR 06/05/24 (20)

9.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

DR 06/05/25 (20)

Job Completion



DR 06/05/25

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                 |                          |
|------|------|--------------------|----|------|-----|---------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Mfg / Design<br>Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                 |                          |
|      |      |                    |    |      |     |                                 |                          |

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                  |                |                           |                        |                          |
|------|------|----------------------------------|-----------------------------|----------------------------------|----------------|---------------------------|------------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                  |                | Verification<br>Section C | Approval<br>Design Mgr | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Design Mgr       | Action Description<br>Design Mgr | Sign &<br>Date |                           |                        |                          |
|      |      |                                  |                             |                                  |                |                           |                        |                          |
|      |      |                                  |                             |                                  |                |                           |                        |                          |
|      |      |                                  |                             |                                  |                |                           |                        |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

|                       |              |             |
|-----------------------|--------------|-------------|
| DART AEROSPACE LTD    | Work Order:  | 27050A      |
| Description: Strut    | Part Number: | D2324-3     |
| Inspection Dwg: D2324 | Rev: C       | Page 1 of 1 |

# FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

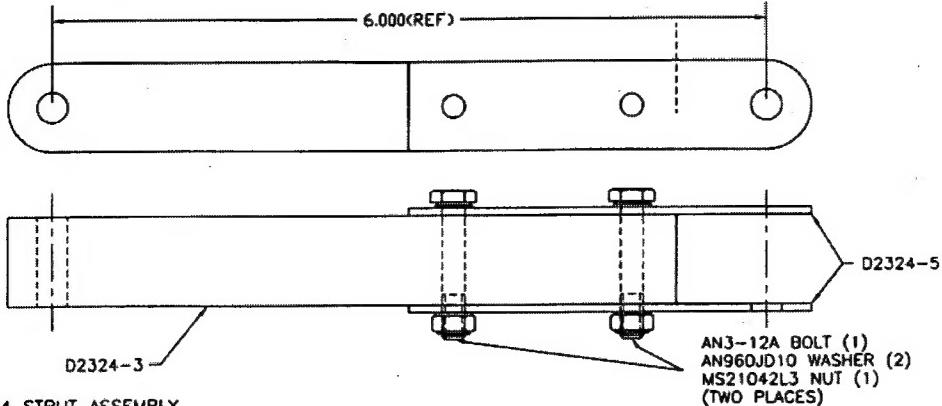
|              |                 |             |                 |                     |     |
|--------------|-----------------|-------------|-----------------|---------------------|-----|
| Measured by: | <u>S.A</u>      | Audited by: | <u>J.G.</u>     | Prototype Approval: | N/A |
| Date:        | <u>06.05.17</u> | Date:       | <u>06/05/17</u> | Date:               | N/A |

| <b>Rev</b> | <b>Date</b> | <b>Change</b>         | <b>Revised by</b> | <b>Approved</b>    |
|------------|-------------|-----------------------|-------------------|--------------------|
| A          | 04.06.10    | New Issue P/O D2324-1 | KJ/JLM            | <i>[Signature]</i> |
| B          | 06.03.08    | Dwg Rev changed       | KJ/JLM            | <i>[Signature]</i> |

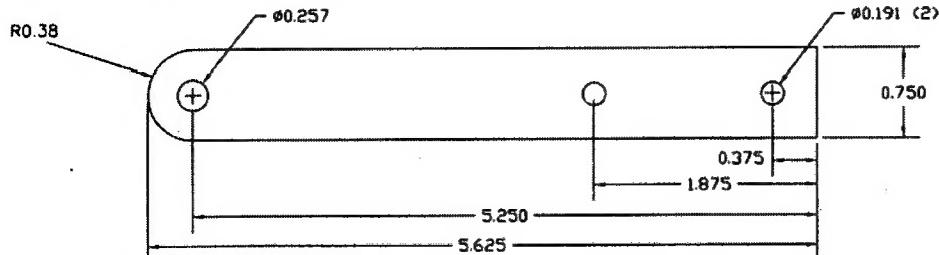
**DART**

|                               |                                  |  |
|-------------------------------|----------------------------------|--|
| DESIGN<br>B. WILLIAMS         | DRAWN BY<br>PH                   | DART AEROSPACE LTD<br>VICTORIA INTERNATIONAL AIRPORT, CANADA |
| CHECKED<br><i>[Signature]</i> | APPROVED<br><i>[Signature]</i>   | DRAWING NO.<br>D2324   |
|                               |                                  | REV. C<br>SHEET 1 OF 1                                       |
| DATE<br>04.12.14              |                                  | TITLE<br>STRUT   |
| A<br>B<br>C                   | 94.11.08<br>96.05.07<br>04.12.14 | SCALE<br>NEW ISSUE<br>UPDATE MATERIALS<br>UPDATE NOTES       |

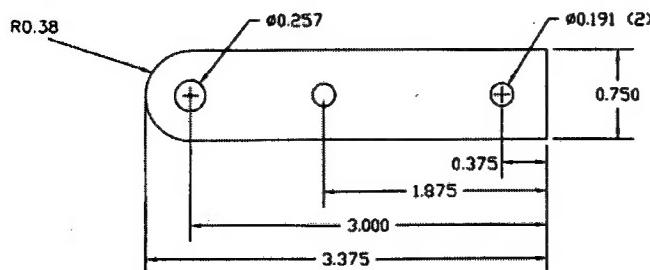
RELEASED

04.12.16 *[Signature]***D2324 STRUT ASSEMBLY**

1) IDENTIFY WITH DART P/N D2324 USING FINE POINT PERMANENT INK MARKER

**D2324-3**

- 1) MATERIAL: 6061-T6/T651 BAR (QQ-A-200/8) 0.75 X 0.75  
(REF DART SPEC. M6061T6B0.750X00.750)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDERCOAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

**D2324-5**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET 16 GAUGE (0.063 THICK)  
(REF DART SPEC. M304S16GA)
- 2) FINISH: POWDERCOAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY  
RETURN TO  
ENGINEERING

UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO 27050A